

Work Order ID 66569

Tuesday, February 22, 2011 10:28:57 AM



Page 1

Item ID: D4151-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Hardpoint Plate

Start Date: 2/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-02-22 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4151	C								

100 0.00



Waterjet
FLOW CNC Waterjet

304 .125

Memo

Cut as per dwg D4151

Prog Rev: C

Dwg Rev: C

Deburr as required

0.00

11-2-22

110 0.00



QC
Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

11-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66569

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Item ID:	D4151-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Upper Hardpoint Plate				Stop	
Start Date:	2/23/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	3/9/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, February 22, 2011 10:28:54 AM

Page 1

Work Order ID: 66569



Parent Item: D4151-3



Parent Item Name: Upper Hardpoint Plate



Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	46.5800	0.055	0.347368			
											VB 11-2-22		

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT

46.58

116623

46.58

116623

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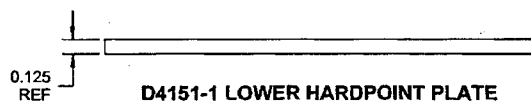
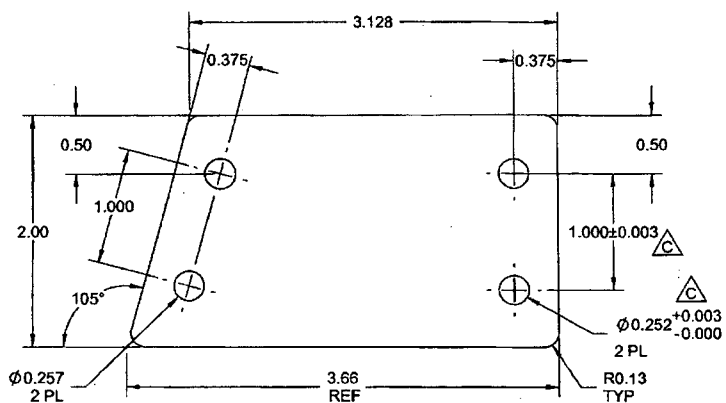
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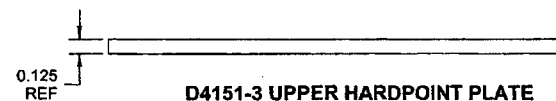
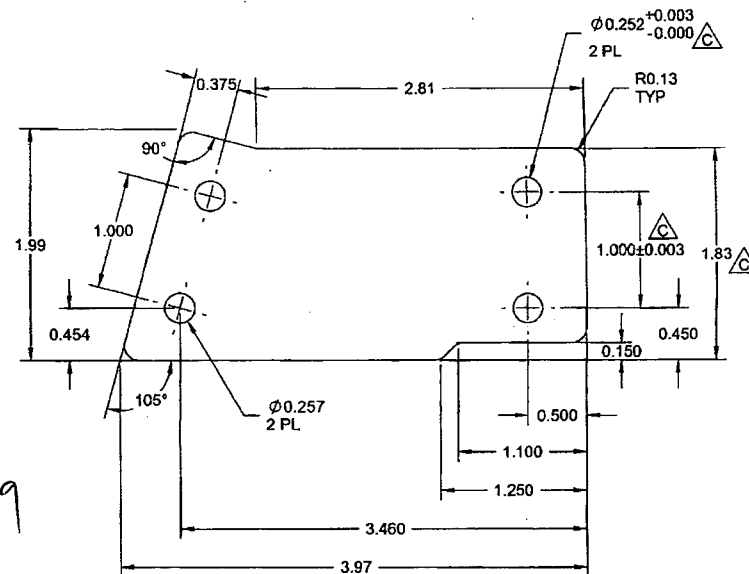
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4151-1 LOWER HARDPOINT PLATE



D4151-3 UPPER HARDPOINT PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
 - D4151-1 = 0.24 lbs
 - D4151-3 = 0.23 lbs

RELEASED
R 2011-01-18
JMD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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